



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

6F9540V00231
Job Sheet 178070



Part No: 6F9540V00231

Job Qty: 1 ea

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 8/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/6/18	0.00	0.00	Start Up Stores/Pkg-2		AUG 10 2018
100	Packaging	1 pcs		8/6/18	0.00	0.00	Packaging1-6		AUG 10 2018
105	QC	1 pcs		8/6/18	0.00	0.00	QC4		AUG 10 2018
120	Packaging	1 pcs		8/6/18	0.00	0.00	Packaging3-1		AUG 10 2018
125	DC	1 pcs		8/6/18	0.00	0.00	DC		AUG 21 2018
130	QC21-FG	1 Ea		8/6/18	0.00	0.00	QC21		AUG 21 2018

Part Op 120 - Identify and pack for shipping as per PPP 6F9540V00231

Descriptions: 125 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D169-841-015	AW169 Lower Cutter	1 Ea (1 ea)	90-Start up Operation	5100979

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D169-841-015	1	0	0

Part Specifications

Specifications could not be found.

Plex 6/20/18 9:51 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Ord Part NC Date :	 DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Inapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		
		QTY Effective :		MRB (QSI042) Approval
		Disposition		Completed By
				Lead hand / Supervisor Approval Verification
				QC / QA Coordinator Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

FAULT CATEGORY

Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER : ☐

		Supplier Concession				PAGE 1 of 2	PLANT Leonardo Helic. - Vergiate	
Supplier NC N.	AWC-009/00		Date	21.08.2018		AW Concession	400000075161	
P/N	6F9540V00231		Grade/Category	NC		Purchase Order	4801761207	
Part Description	PROTECTR, CCP ASSY LOWER		Batch Quantity	2,000		Defective Quantity	2,000	
AW NC	FRANCESCO NAVA		A/C Type/Model	AW6				
Supplier	DART AEROSPACE LTD		Contract					
Defect PR10 - Working different from requirements (spe - * 21.08.2018 08:41:44 FRANCESCO NAVA (46232) * See supplier document attached Cause of Defect								
Repetitiveness (same P/N - Defect Code) NO ☐ YES ☒ (1)								
ENGINEERING Evaluation and Proposal								
Engineering Evaluations, including Specialist inputs: * 21.08.2018 09:51:23 MARCELLO STEFANELLI (9273) * As for the attached consideration, the deviation doesn't affect the strenght and functionality of the part, it is acceptable use as is.			Investigation Report n.			Compliance Report n.		
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B								
Defect effect						Limitations		
	Before Repair		After Repair					
Safety	☐	YES	☐	YES ☐ NO	☐ YES (to specificity) ☒ NO			
Life or Duration	☐	YES	☐	YES ☐ NO				
Strenght	☐	YES	☐	YES ☐ NO				
Performances	☐	YES	☐	YES ☐ NO				
Interchangeability	☐	YES	☐	YES ☐ NO				
Reliability	☐	YES	☐	YES ☐ NO				
Maintainability	☐	YES	☐	YES ☐ NO				
Installability	☐	YES	☐	YES ☐ NO				
Testability	☐	YES	☐	YES ☐ NO				
Only Appearance	☐	YES	☐	YES ☐ NO				
No Effect	☒	YES	☐	YES ☐ NO				
Repair Proposal:					Decision ☐ Use rep. with spec.repair(not yet applied) ☐ Use repaired with known repair(yet applied) ☒ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification			☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO	
Mark part with Concession			☒ NO ☐ YES		Method :			
ATE	MARCELLO STEFANELLI		CPE			Date	21.08.2018	
Checks and tests to be performed								
Repair registration								
with repair WO ☐ Number:								
Repair Evaluation:								
Final Decision								
S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	
S101005	☒	☐	☐		☐	☐	☐	
S101006	☒	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
Not Serialized	Use As Is (Q.ty)	2,000	Use Repaired (Q.ty)		Scrap (Q.ty)			
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative		
Signature	MARCELLO STEFANELLI			FRANCESCO NAVA				
Date	21.08.2018			21.08.2018				



Supplier Concession

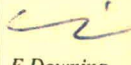
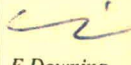
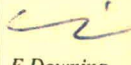
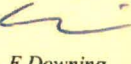
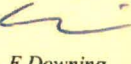
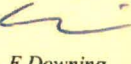
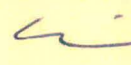
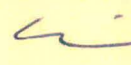
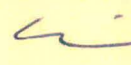
PAGE

2 of 2

PLANT

Leonardo Helic. - Vergiate

Supplier NC N.	AWC-009/00	Date	21.08.2018	AW	400000075161	Purchase Order	4801761207
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 AgustaWestland A Finmeccanica Company		CONCESSION				Pag. 1 of 2									
<i>Manuf. Doc. N.</i>	AWC-009	<i>Date</i>	2018/08/13	<i>AW Doc. N.</i>		<i>Purchase Order</i>	4801761207								
<i>AW P/N</i>	6F9540V00231	<i>S/N / Batch Number</i>	S101005 S101006	<i>Grade</i>	A	<i>AW Drawing Issue</i>	B								
<i>Description</i>	Protector, CCP Lower Assembly			<i>Batch Q.ty</i>	2	<i>Defective Q.ty</i>	2								
<i>Manufacturer</i>	Dart Aerospace LTD			<i>Model</i>	AW169										
<i>Defect(s) Description</i>															
The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.															
				<table border="1"> <tr> <th><i>Department</i></th> <th><i>Inspector</i></th> <th><i>Signature</i></th> <th><i>Date</i></th> </tr> <tr> <td>Quality Assurance</td> <td>DAS 16 9-89 DAS-16-9-89</td> <td> E. Downing</td> <td>2018/08/13 2018/08/13</td> </tr> </table>				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>	Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/08/13 2018/08/13
<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>												
Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/08/13 2018/08/13												
<i>Defect(s) Cause</i>															
Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.															
				<table border="1"> <tr> <th><i>Department</i></th> <th><i>Inspector</i></th> <th><i>Signature</i></th> <th><i>Date</i></th> </tr> <tr> <td>Quality Assurance</td> <td>DAS 16 9-89 DAS-16-9-89</td> <td> E. Downing</td> <td>2018/07/13 2018/07/13</td> </tr> </table>				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>	Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/07/13 2018/07/13
<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>												
Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/07/13 2018/07/13												
<i>Corrective Action</i>						<i>Complete Before</i>									
Dart Aerospace HBY requesting drawing update to allow for grain direction change on D4842-1															
				<table border="1"> <tr> <th><i>Department</i></th> <th><i>Inspector</i></th> <th><i>Signature</i></th> <th><i>Date</i></th> </tr> <tr> <td>Quality Assurance</td> <td>DAS 16 9-89 DAS-16-9-89</td> <td> E. Downing</td> <td>2018/07/13 2018/07/13</td> </tr> </table>				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>	Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/07/13 2018/07/13
<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>												
Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/07/13 2018/07/13												

For "MANUFACTURER" SUPPLIERS ONLY

ENGINEERING evaluation and proposal

Engineering evaluation

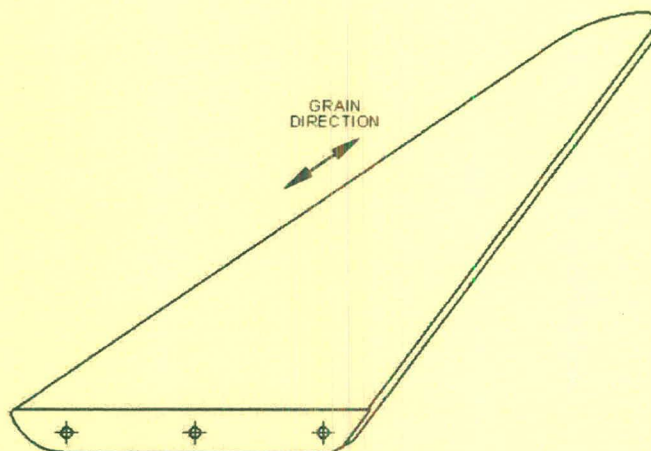
Investigation report

n: NCR18-6764

Compliance report

n...N/A.....

Grain direction was rotated 56° to align with the leading edge of the deflector. This orientation allows for a smaller raw material blank size and significantly reduce material scrap. The grain direction is still effectively perpendicular to the bending plane from cable loads. The effect on strength is insignificant.



	Defect effects		Limitations
	Before any repair	After any repair	
	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Safety	☐ yes	☐ yes ☐ no	
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal		Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☐ Scrap	
Concession Classification	☒ Major ☐ Minor		Submit after repair ☐ yes ☐ no